

Date: Monday, 2/27/2006 1:36:39 PM
 User: Linda Lacelle

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSTUBE EXTRUSION (412 AFT)
Job Number	: 25942		
Estimate Number	: 10030		
P.O. Number	: N/A	Part Number	: D6009129
This Issue	: 2/27/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D6009 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25668	Drawing Revision	: A
	Type : LANDING GEAR	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/6/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	20 Um: Each
Comment	: Est Rev:A 01.08.17 New Issue SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000670

a) Order as per Dwg D6009

b) Material: 3.500 x 0.625 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Tolerance are per ASTM B210 (see details on Dwg D6009)

f) Material certification required

2.0	D6009129P	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Crosstube Material

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QQ-A-225/9	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CROSSTUBE EXTRUSION (412 AFT)

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Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



N/A

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MAL-26

TC 06-05-08

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

20
06/05/08
06-05-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Customer PO	P.O.00000670
ALUnna ref. no.	17896/1
Date:	04.26.06

Dart Aerospace P.O.00000670 Box No.
D6009-129 Made in Germany
Dest.Hawkesbury Ont Canada

Free from live plant pests

[illegible]

**ALUnna**

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.
Client: 1270 Aberdeen Street
 K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 364/06
Cert No. / No. du certificat:

Bestellnummer: PO 00000670
Order No. / No. de commande

Auftrag: 17896/1
Our Reference/Notre Reference:

Produkt: Rohre nahtlos gepresst
Product / Produit: Tubes seamless extruded
Spezifikation: -; AMS - QQ - A - 200/11E; -; -;
Specification:

Werkstoff: 7075
Alloy/Alliage:

Zustand: T 6511
Temper/État

Abmessung: 3,500 INCH x 2,250 INCH x 0,625 INCH x 129,000 INCH
Size / Dimension: D6009-129 3.500 X 0.625 X 129

Kennzeichnung: ALUnna-Cert No.364/06-7075-T6511-Cast No.80117-QQA-200/11E-3.500" OD X 0.625"Wall-Heat No.421/04-
Marking/Marquage: Lot17896/1-1-P.O.00000670

Lieferung: pcs. lbs
Delivered Material / Matériel délivré: 22 1629

1. Chemische Analyse Chemical Analysis / analyse chimique

Charge/ Cast No	min. max.	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
		0,40	0,50	1,2 2,0	0,30	2,1 2,9	0,18 0,28	5,1 6,1	0,20					
80117		0,07	0,15	1,53	0,04	2,48	0,19	,87	0,04	<0,05				

Elements without indication < 0,01 %

2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

An Re	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat No.
min. max.	77,0	66,0				
1	86,565	79,315	11,0	11,0	176	421/04 - 22 pcs.
2	87,145	80,185	10,0	10,0	173	
3	86,855	79,460	10,5	10,5	173	
4	86,855	79,895	12,0	12,0	178	

Ergebnis der Prüfungen: Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results: We confirm that the delivery has been tested and applies to the agreements made on receipt of the order
Résultats: Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande